

Date: Thursday, 13/11/2008 1:06:31 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 350 SADDLE
Job Number	: 43423		
Estimate Number	: 12451		
P.O. Number	:	Part Number	: D35001
This Issue	: 13/11/2008 S.O. No. :	Drawing Number	: D3500 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 43396	Material	:
Written By	:	Due Date	: 20/12/2008
Checked & Approved By	: <u>JLD 08.11.14</u>	Qty:	10 ⁵ Um: Each
Comment	: Est Rev:A New Issue 06-06-15 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6102013	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

6061-T6 7.0x6.5x2.0

350 Saddle Billet

Batch: B41962JLD 08/11/14

⑤

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 43423 Double check by: DTP

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets

4-Deburr

5-Tumble to remove sharp edges.

JLD 08/11/14

⑤

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD 08/11/14

⑤

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 08/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief/Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:06:31 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 43423

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

HL 08-11-20 (5)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*8:15
320°F
8:45*

m-h 08/11/21

(5X)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

P 8/11/24 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57432 P 8/11/24 (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26 JF

Job Completion



mf 08-11-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: <u>NJ 3423</u>	
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.178	1.180	1.180	1.179		
C	3.145	3.155		3.149	3.149	3.180	3.148		
D	1.175	1.185		1.178	1.180	1.180	1.179		
E	0.365	0.385		.371	.371	.372	.372		
F	0.490	0.510		.501	.499	.500	.502		
H									
I	R1.575	R1.595		1.587	1.586	1.586	1.586		
J	0.240	0.260		.241	.246	.246	.244		
K	0.490	0.510		.499	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320	322	.321	.321	.321	.321		
N	0.256	0.262		.258	.259	.259	.259		
O	6.500	6.520		6.505	6.505	6.505	6.505		
P	5.990	6.010		6.006	6.006	6.006	6.004		
Q	2.820	2.830		2.827	2.827	2.827	2.827		
R	2.495	2.505		2.499	2.499	2.500	2.500		
S	2.245	2.255		2.249	2.251	2.250	2.251		
T	1.120	1.130		1.122	1.124	1.127	1.124		
U	0.540	0.560		.555	.554	.557	.557		
V	0.793	0.803		.798	.798	.798	.799		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.131	1.131	1.131		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.256	.258	.257	.256		
AE	1.810	1.830		1.820	1.821	1.821	1.820		
AF	0.240	0.260		.251	.249	.251	.249		
AG	0.140	0.160		.152	.151	.151	.151		
AH	0.140	0.160		.158	.158	.159	.158		
AI	0.140	0.160		.153	.154	.152	.154		
Accept/Reject									

Measured by:	<u>gmy</u>
Date:	<u>08/11/19</u>

Audited by:	<u>24</u>
Date:	<u>08/11/20</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	<u>JD</u>

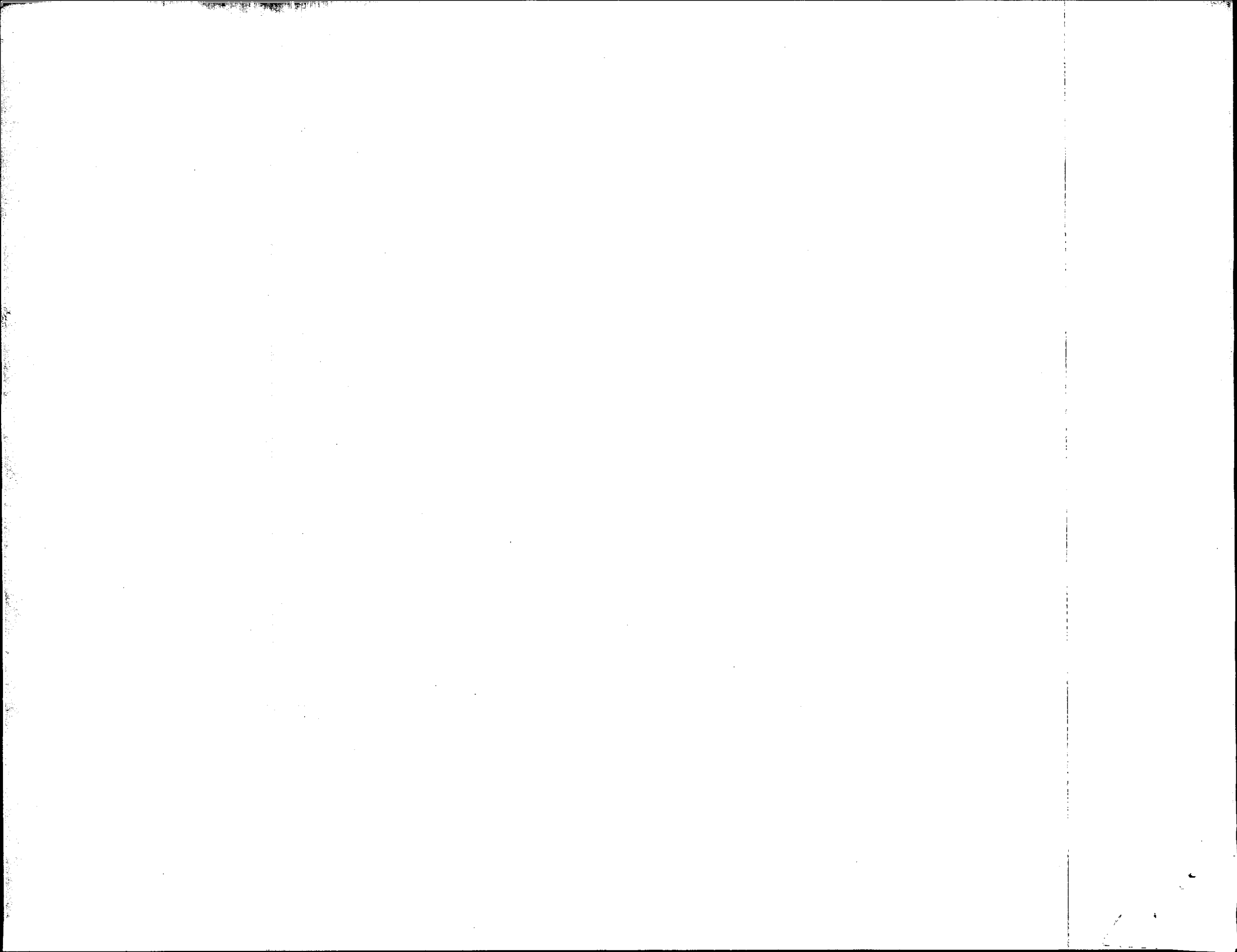
DART AEROSPACE LTD		Work Order: 43423
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500	Rev: C	Page 1 of 1

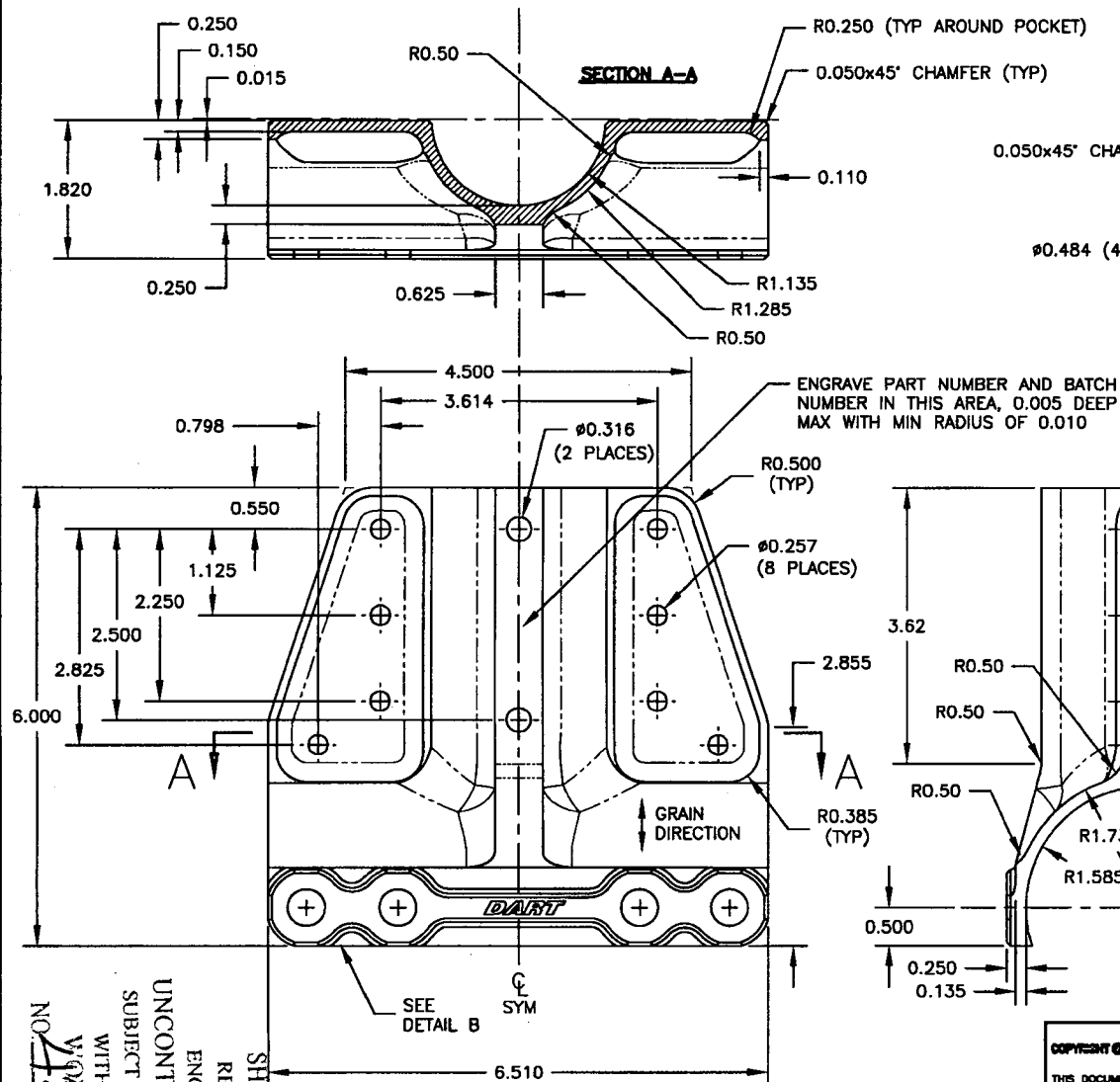
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487					
B	1.175	1.185		1.180					
C	3.145	3.155		3.150					
D	1.175	1.185		1.180					
E	0.365	0.385		.372					
F	0.490	0.510		.501					
H									
I	R1.575	R1.595		1.590					
J	0.240	0.260		.244					
K	0.490	0.510		.500					
L	3.590	3.650		3.620					
M	0.315	0.320		.321					
N	0.256	0.262		.258					
O	6.500	6.520		6.508					
P	5.990	6.010		6.005					
Q	2.820	2.830		2.827					
R	2.495	2.505		2.500					
S	2.245	2.255		2.250					
T	1.120	1.130		1.122					
U	0.540	0.560		.555					
V	0.793	0.803		.798					
W	R.240	R.260		.266					
X	0.040	0.060		.050					
Y	0.100	0.120		.110					
AA	R1.125	R1.145		1.131					
AB	R.490	R.510		.500					
AC	0.615	0.635		.630					
AD	0.240	0.260		.258					
AE	1.810	1.830		1.820					
AF	0.240	0.260		.250					
AG	0.140	0.160		.151					
AH	0.140	0.160		.158					
AI	0.140	0.160		.132					
Accept/Reject									

Measured by:	QML
Date:	08/11/19

Audited by:	RQ
Date:	08/11/20

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	





D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

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C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	97	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	TITLE
		SADDLE
		REV. C
		SHEET 1 OF 1
		SCALE
		2:3

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